

Work Order ID 64458

Page 1

Monday, December 06, 2010 10:22:33 AM

Item ID: D2803-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 12/6/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: MFDate: 10-12-06

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2803

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per FILE D2803-1

6061, 500X 10"

Dwg Rev: B
Prog Rev: B

2-Deburr if necessary

B 10-12-14(B)

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio FA102

on 10/12/14B 10-12-14

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

on 10/12/146

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 2803-1 PAR #: _____ Fault Category: Small Rab/W-Jet NCR: (Yes) No DQA: [Signature] Date: 10/12/15
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 10/12/20

NCR: 64458		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/12/14	100	1 part scrap on the water jet the holding hole are wrong plate, blank shifted: holes too bolt down in the CMC run over the edge of the blank. R.C: LOA.	[Signature]	Material is identified with its original Mtl batch #. Identify for tooling use, it possibly can be used for another Q-part.	[Signature] 10/12/15	B.A 10/12/15	[Signature] 10/10/12	[Signature] 10/12/15

NOTE: Date & initial all entries

Work Order ID 64458

Monday, December 06, 2010 10:22:33 AM



Page 2

Item ID: D2803-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 12/6/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

HA 10/12/15

6

0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10 12 15 (6)

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 10-12-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64458

Monday, December 06, 2010 10:22:33 AM



Page 3

Item ID: D2803-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 12/6/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: CAF

0.00



Packaging

Memo

64092

0.00

20 10/12/17



Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/2010
MK
10-12-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, December 06, 2010 10:22:37 AM

Page 1

Work Order ID: 64458



Parent Item: D2803-1



Parent Item Name: Bracket

Start Date: 12/6/2010

Required Date: 12/13/2010

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP A 00.11.06 New Issue EC

IPP Rev:B Blanks Now Cut on Waterjet 06-06-14 JLM

IPP Rev:C Removed Tumbling 08-09-10 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B0.500X10.00
0

Purchased

No

100

f

40.0000

1.9167

12.10547

13



6061-T6 Bar .500 x 10.00

1310-13-14

Location

Loc Qty

Loc Code

MAT05

40

111382

28

112764

12

111382

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 64458
Description: Bracket		Part Number: D2803-1
Inspection Dwg: D2803	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	Ø.760	—		Micr	ML-01
Ø0.191	+0.005/-0.000	Ø.193	—		Vern	ML-7
Ø0.507	+0.000/-0.001	Ø.5068	—		Micr	ML-01
13.558	+/-0.010	13.558	—		M-tape	ML-2
Ø0.507	+0.000/-0.001	Ø.5063	—		Micr	ML-01
12.411	+/-0.010	12.411	—		M-tape	ML-2
2.654	+0.000/-0.001	2.654	—		Vern	ML-7
0.437	+0.000/-0.001	.437	—		Vern	ML-7
1.420	+/-0.001	1.419	—		"	"
6.933	+/-0.010	6.933	—		M-tape	ML-2
0.250	+/-0.010	.248	—		Vern	ML-7
0.875	+0.000/-0.001	.875	—		Micr	ML-01
0.250	+0.000/-0.005	.249	—		Depth-gage	ML-05
0.125	+/-0.010	.120	—		Vern	ML-7
0.125	+/-0.010	.122	—		"	"
0.125	+/-0.010	.122	—		"	"
0.125	+/-0.010	.124	—		"	"
0.500	+/-0.010	.500	—		"	"
0.562	+/-0.010	.562	—		"	"
0.188	+/-0.010	.189	—		"	"

Measured by: <i>cmf</i>	Audited by: <i>M.A</i>	Prototype Approval:	N/A
Date: 10/12/14	Date: 10/12/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	07.07.18	12.625 dimension removed	KJ/JLM <i>AF</i>	<i>BE</i>

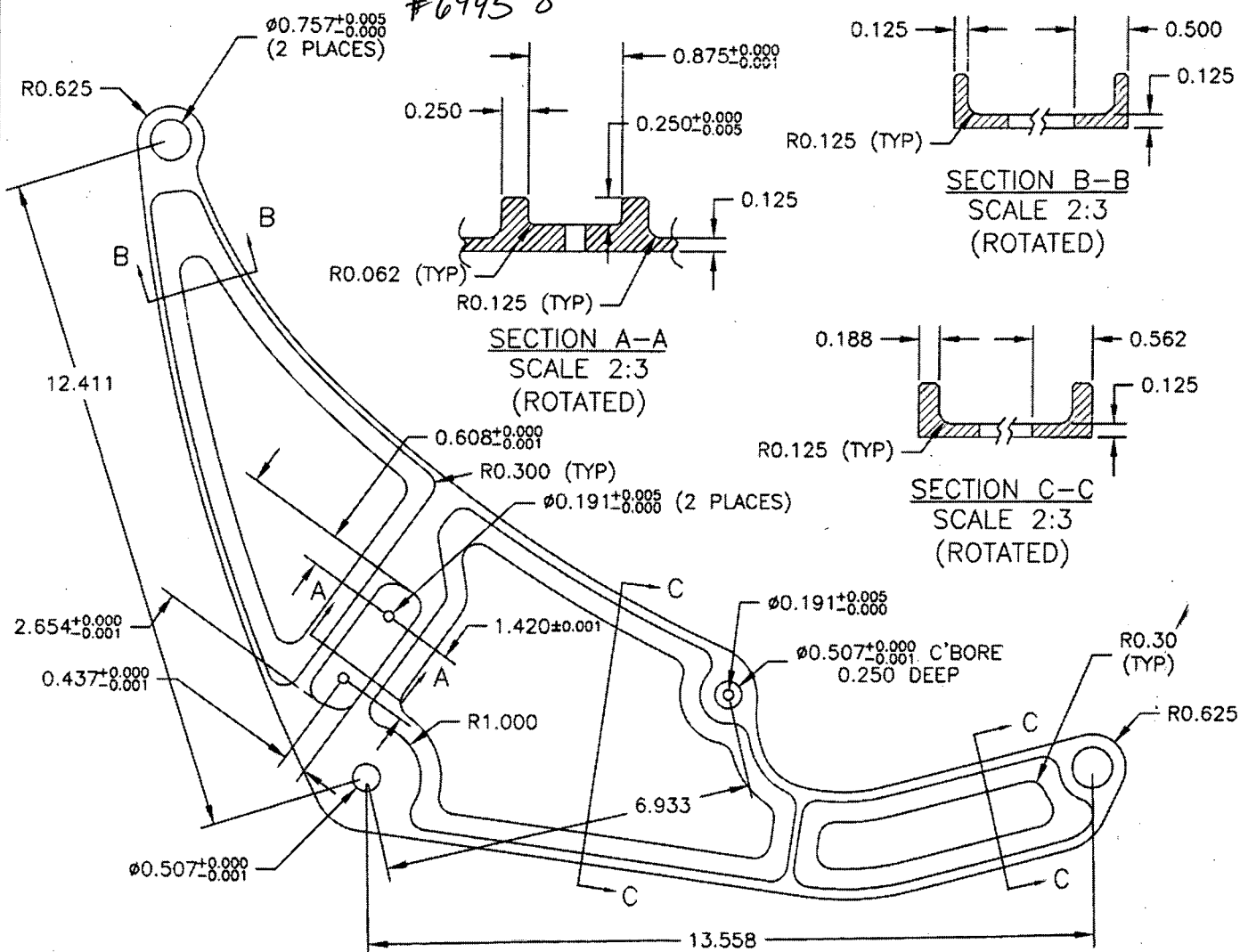
DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	SHEET 1 OF 2
				D2803	
DATE	04.11.22			TITLE	SCALE
				STA 84 BRACKET	1:3
A	00.11.07			NEW ISSUE	
B	04.11.22			ADD CUTOUTS & -043/-044	

RELEASED

05.03.11

#64458

**D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

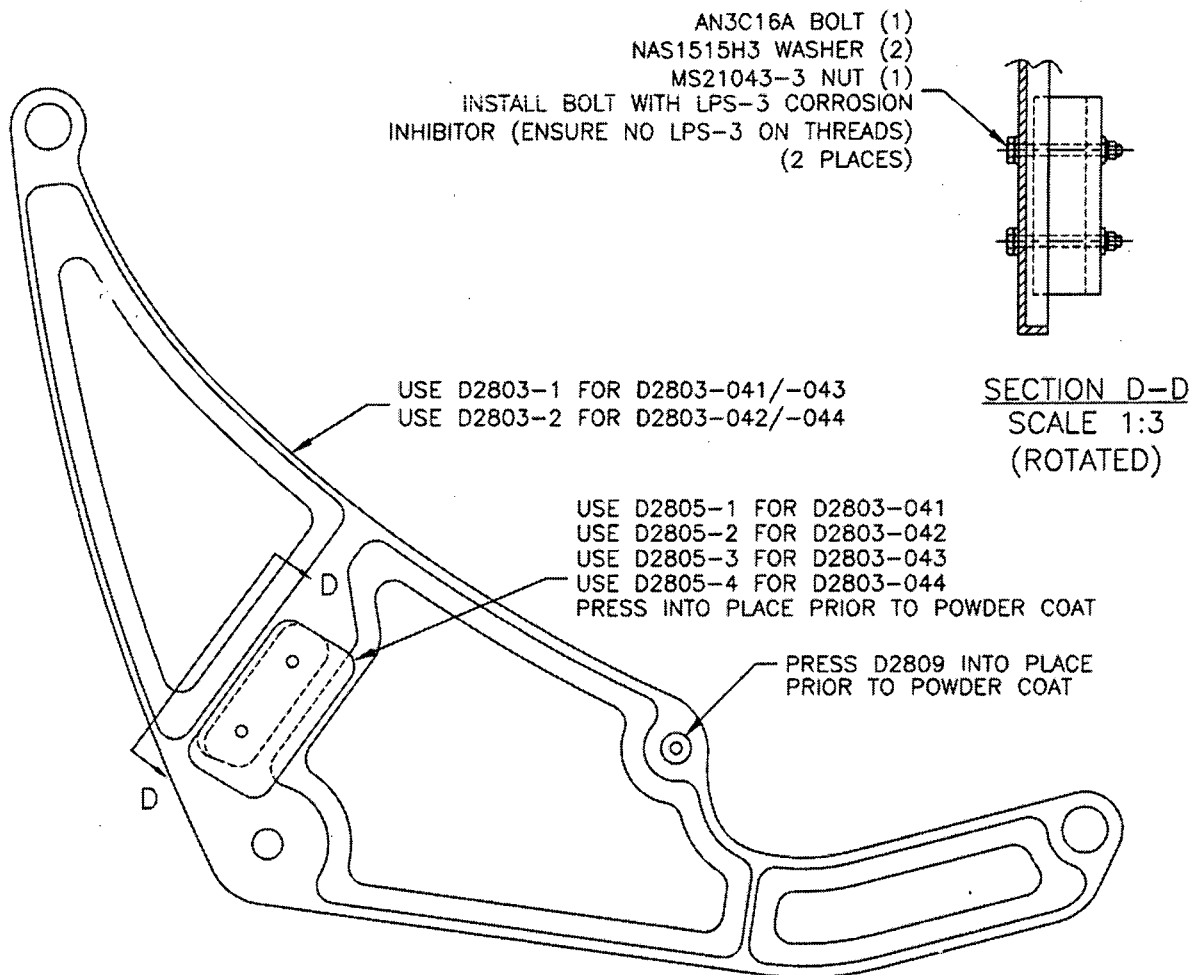
- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURP TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



#64458

RELEASED

05-03-11

D2803-041/-043 BRACKET ASS'Y (SHOWN)
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.